

Work Order ID 66005

Tuesday, February 01, 2011 12:58:32 PM



Page 1

Item ID: D3391-021

Accept



Setup Start



Revision ID:

Item Name: Fwd Tube Assembly

Stop



Start Date: 2/2/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 2/15/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan: *mf*

Date: 11-02-01

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3391

Rev H

100

0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

Cut extrusion to 46.52 +0.010 -0.020

DP

11-2-2

110

0.00



BENDING MACHINE - SKIDTUBES

CNC Bend 1

Memo

0.00

CNC Delta 100 Bender

Bend as per Dwg D3391 Using Bend Prog 3391021

DP

11-2-2

120

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

h = 6.8"

L = 12.8"

Subtotal

(X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 66005

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Page 3

Item ID: D3391-021

Accept



Setup Start



Revision ID:

Stop



Item Name: Fwd Tube Assembly

Start Date: 2/2/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 2/15/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC2- Inspect parts off machine FAI/FAIB

0.00

SL 11/02/16



QC

Memo

0.00

Quality Control

170

QC8- Inspect parts - second check

0.00

aml 11/02/16



QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____






NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries


Work Order ID 66005


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Item ID:	D3391-021	Accept		Setup	Start	
Revision ID:						
Item Name:	Fwd Tube Assembly				Stop	
Start Date:	2/2/2011	Start Qty:	1.00		Cust Item ID:	
Required Date:	2/15/2011	Req'd Qty:	1.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:
	QC:	Date:	SPC (Y/N):	Date:

Run	Start	
	Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	Skidtubes	0.00							
	Skidtubes								
Skidtubes	Memo	0.00							
	<p>1-Drill float bag holes as per Dwg D3391 using DT8798(Do not open tow cap holes to finish size) (ONLY DRILL HOLES MARKED "A")</p> <p>2-Drill Remaining two holes for tow cap using DT 8819 Locating off of .1875" holes drilled in previous step</p> <p>3-Open tow cap holes to .208" as per Dwg D3391</p> <p>4-Open Tow Ring hole to .640" as per Dwg D3391</p> <p>5- open float bag holes 0.328" and counter sink as per dwg D3391</p> <p>6-Deburr & Scribe Batch number Inside aft end.</p> <p>7-Transfer drill D3391-021 with D3391-023 N/A</p> <p><i>Drill Fwd Saddle Holes according D3391</i></p> <p>QC5- Inspect part completeness to step on W/O</p>								
	Memo	0.00							
190	QC								
Quality Control									

BE 11/02/23

11-2-23

11/2/23

Drill Fwd Saddle Holes according D3391

QC5- Inspect part completeness to step on W/O

0.00 2 wasp holes

Sum/v P

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

[illegible]

Tuesday, February 01, 2011 12:58:32 PM

Accept

Setup Start

(b) (7)(C), (b) (7)(D)

Stop

[illegible]**Cust Item ID:**

Start Date: 2/2/2011 **Start Qty:** 1.00

1. The first group of four bars represents the first four bars of the first measure. The second group of four bars represents the next four bars of the first measure. The third group of four bars represents the next four bars of the first measure. The fourth group of four bars represents the next four bars of the first measure.

1. The first group of four bars represents the first four bars of the first measure. The second group of four bars represents the next four bars of the first measure. The third group of four bars represents the next four bars of the first measure. The fourth group of four bars represents the next four bars of the first measure.

Customer:

Required Date: 2/15/2011 **Req'd Qty:** 1.00

Reference:

Run Start

Abstract

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop

1. The first step in the process is to identify the problem or issue that needs to be addressed. This involves gathering information and understanding the context of the problem.

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Insp:
Stamp

0.00

HandFinish

Memo

0.00

Hand Finishing

0.00

RESEARCH DESIGN

QC

Memo

0.00

Quality Control

0.00

Skidtubes

Memo

0,00

Skidtubes

1-instal spacers as per dwg D3391

A/R Magnabond 6398 batch:

exp. date: 03/2011

cure time 12hrs. as per QSI015

2- grind crossbolt flush

3-back drill crossbolt if necessary

M116227

BE 11/02/23

> BB 11/02/24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 66005

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Item ID: D3391-021

Accept



Setup Start



Revision ID:

Stop



Item Name: Fwd Tube Assembly

Start Date: 2/2/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 2/15/2011 Req'd Qty: 1.00

Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

230



QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

ml *11* *02* *24* *1*

235



Pressure Wash per QSI005 4.3

0.00

HandFinish

Memo

0.00

Hand Finishing

AND REALODINE AS PER PAR09-043

1 *6* *11* *102* *21*

240



White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

Powdercoat

Memo

0.00

Powder Coating

START TIME: *8:30*
OVEN TEMPERATURE: *320°*
FINISH TIME: *9:00*

1 *11-2-05*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 66005

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Item ID: D3391-021

Accept

Setup Start

Revision ID:

Stop

Item Name: Fwd Tube Assembly

Start Date: 2/2/2011 Start Qty: 1.00

Cust Item ID:

Required Date: 2/15/2011 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

250

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

1 0 JH 11/02/28

255

Skidtubes

0.00



Skidtubes

Memo

0.00

Skidtubes

**** install D3591-1 spacer as per DSI9364 and wearplate and gasket as per
DWG ****

1 0 JH 11/02/28

257

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8/11/02/28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 66005

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Item ID: D3391-021

Accept



Setup Start



Revision ID:

Stop



Item Name: Fwd Tube Assembly

Start Date: 2/2/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 2/15/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

260

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

280

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/1/28 (1)

11/02/28

MF
11-02-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, February 01, 2011 12:58:29 PM

Page 1

Work Order ID: 66005

Parent Item: D3391-021

Parent Item Name: Fwd Tube Assembly



Start Date: 2/2/2011

Required Date: 2/15/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP A 05.09.13 New issue KJ/JLM
 IPP B 06.02.10 Dwg rev.D ecn 773 EC
 IPP C 06.05.02 Added inspections EC
 IPP D 07.03.13 rev F dwg EC
 IPP E 07.11.07 revG dwg ecn1053P EC verified by: DD
 IPP Rev:f ECN 1056 07-11-12 DD verified by: EC
 IPP Rev:G 08-09-08 new process (ecn 08-510) DD verified by:EC
 IPP Rev:H 08-09-10 revH as per dwg DD verified by:EC
 IPP Rev J 09.02.02 added hardware EC verified by: DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6013-047 Skidtube Material		Manufactured	No			100	Each	34.0000	1	1			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				LG		34							
				23935		3							
				26547		31							
D3670-4-200 SPACER		Manufactured	No			220	Each	56.0000	4	4			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				LG		56							
				57349		34							
				63317		22							
D3401-041 Tow Cap Assembly		Manufactured	No			255	Each	11.0000	1	1			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				FP		11							
				46029		10							
				50316		1							

DP 11-2-2

BE 11/02/23

B 66041 (x4)

XL 11/02/25

X1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 3

Tuesday, February 01, 2011 12:58:30 PM

Work Order ID: 66005



Parent Item: D3391-021



Parent Item Name: Fwd Tube Assembly

Start Date: 2/2/2011

Required Date: 2/15/2011

Start Qty: 1.00

Required Qty: 1.00

D3672-1 Manufactured No

255

Each

1,307.000

4

4



Phenolic Washer



xl 11/02/28

Location

Loc Qty

Loc Code

ST077

1307

42329

10

52505

297

64177

1000

x4

AELS-1032-130 Purchased No

255

Each

0.0000

2

2



INSERT

11115581



x2 xl 11/02/28

AELS-1032-225 Purchased No

255

Each

0.0000

10

10



INSERT

1110768



x10 xl 11/02/28

Tuesday, February 01, 2011 12:58:30 PM

Shop Packet Print

Page 3

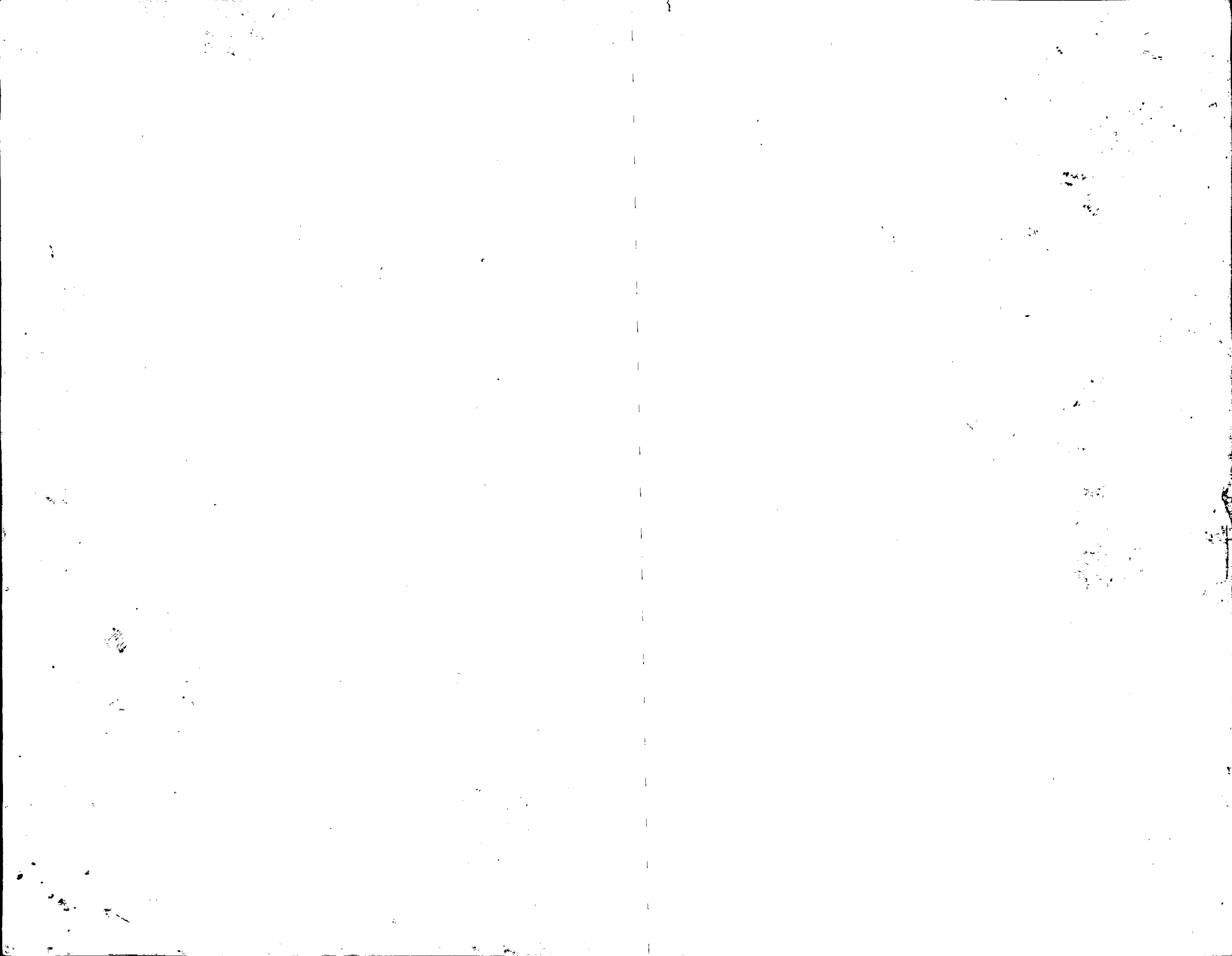
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

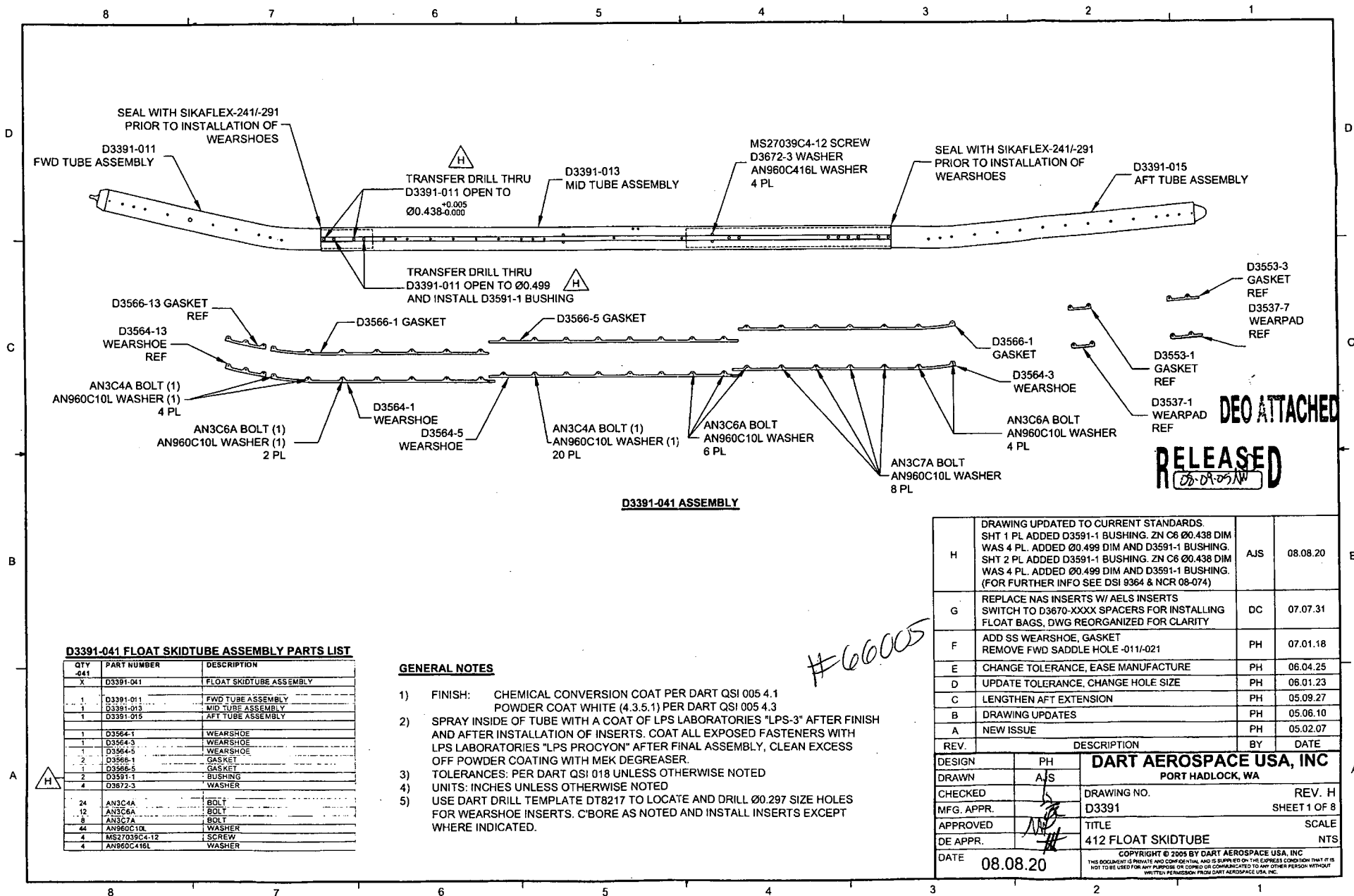
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

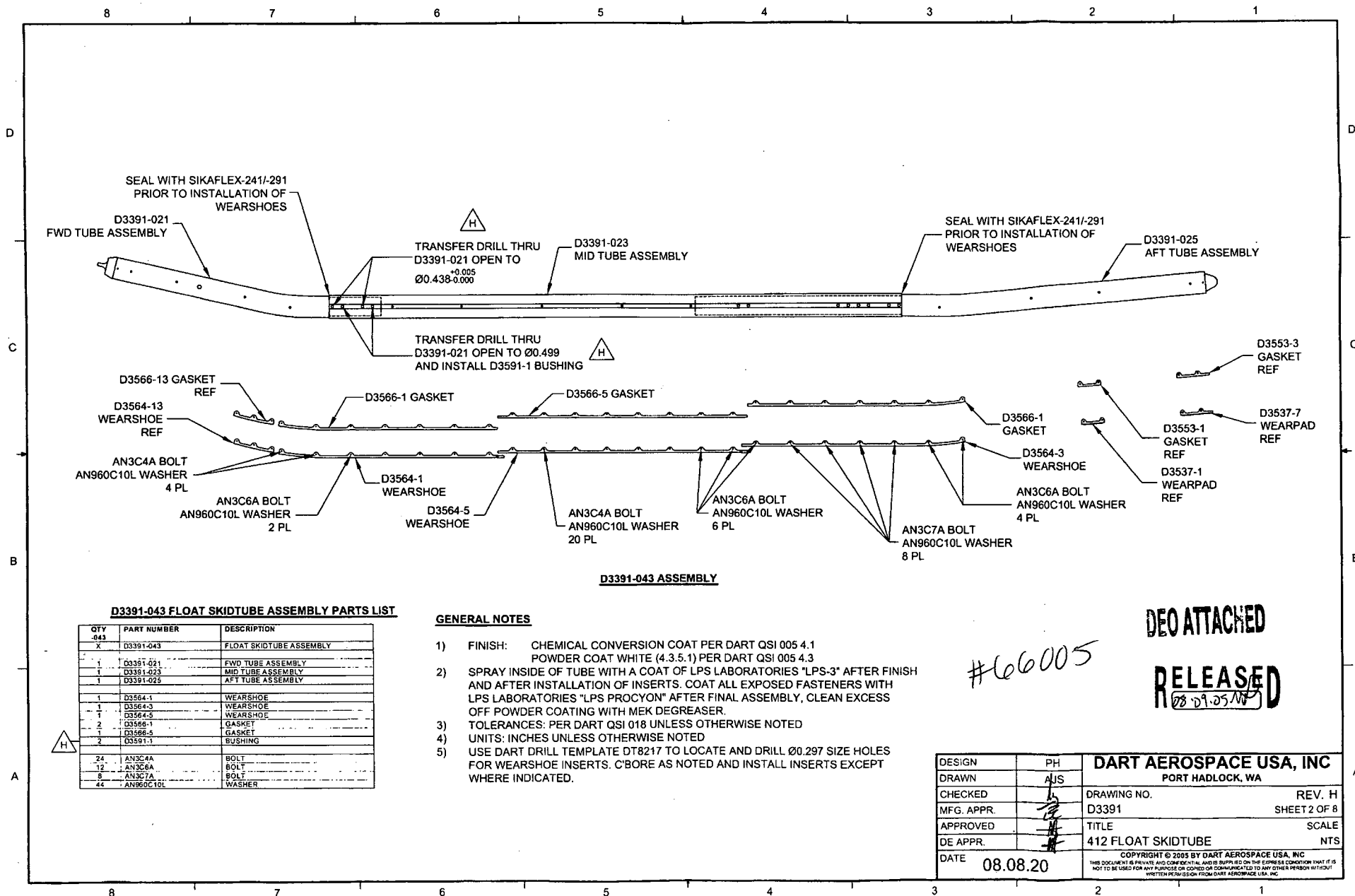
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

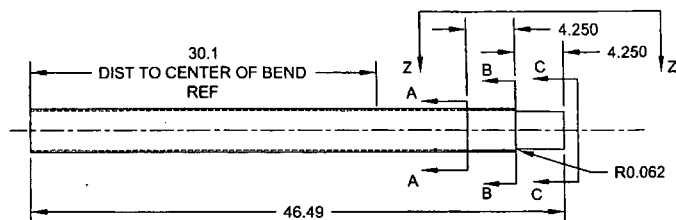
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

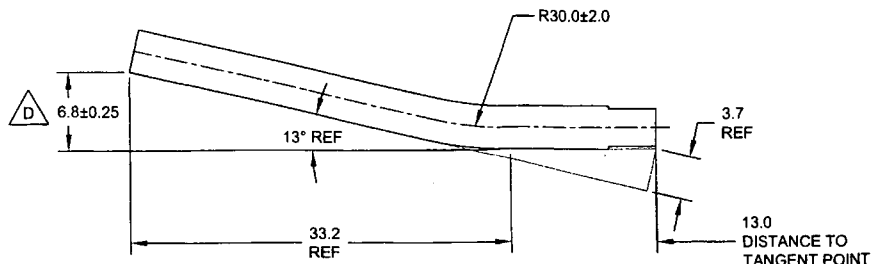




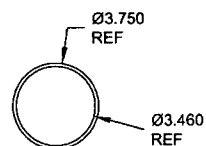




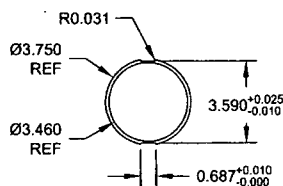
D3391-1 CUTTING DETAIL
(MAKE FROM D6013-047 SKIDTUBE MATERIAL)



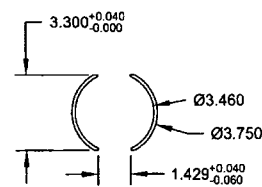
D3391-011/-021 BENDING DETAIL
(MAKE FROM D3391-1)



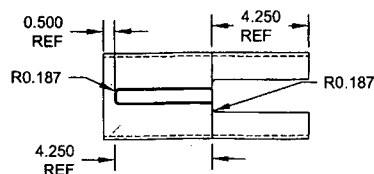
SECTION A-A
SCALE 2X



SECTION B-B
SCALE 2X



SECTION C-C
SCALE 2X

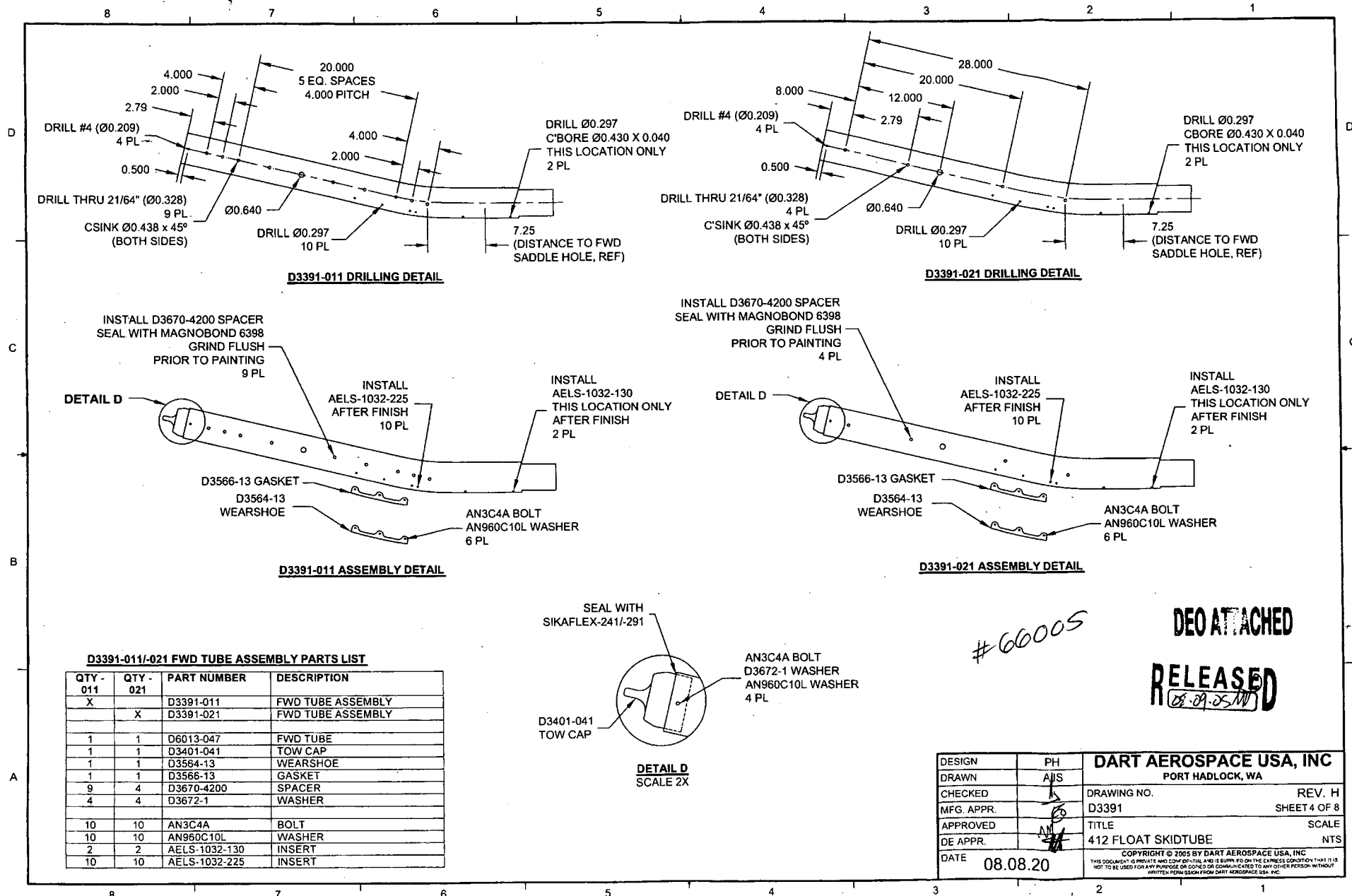


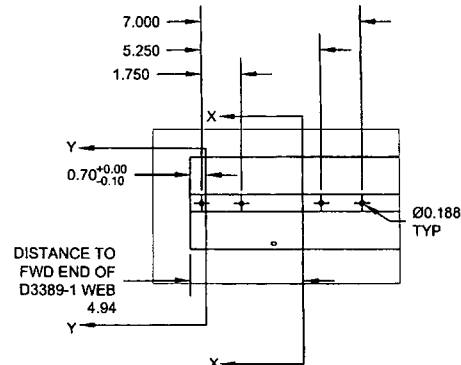
VIEW Z-Z
SCALE 2X

#66005

DEO ATTACHED
RELEASED
8-8-05 NW

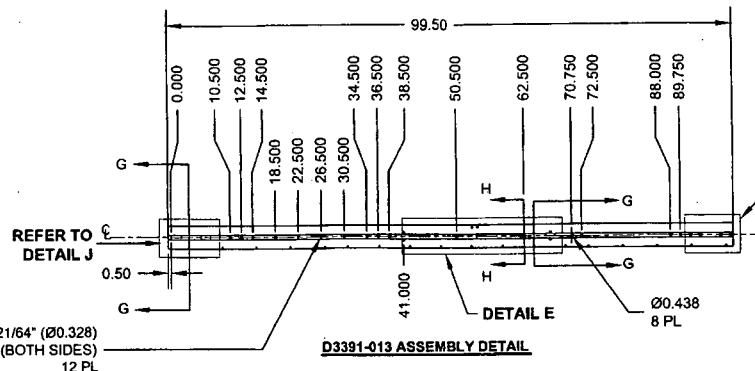
DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	AUS	PORT HADLOCK, WA	
CHECKED	J	DRAWING NO. D3391	REV. H
MFG. APPR.	GC	SHEET 3 OF 8	
APPROVED	AN	TITLE	SCALE
DE APPR.	#	412 FLOAT SKIDTUBE	NTS
DATE	08.08.20	<small>COPYRIGHT © 2005 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMERCE TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC</small>	





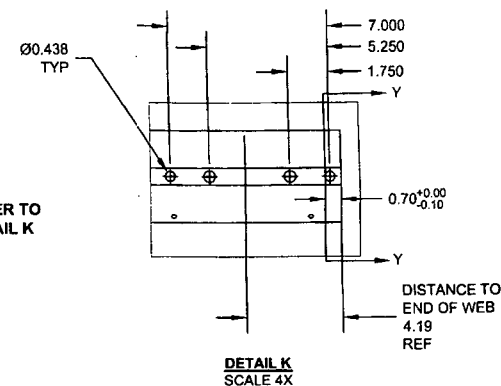
DETAIL J
SCALE 4X

DRILL THRU 21/64" (Ø0.328)
CSINK Ø0.438 X 45° (BOTH SIDES)
12 PL



D3391-013 ASSEMBLY DETAIL
SCALE 5X

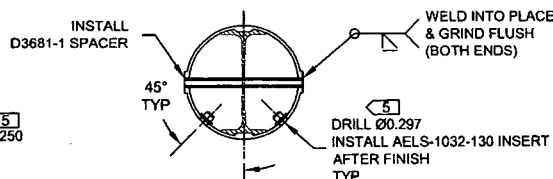
REFER TO
DETAIL K



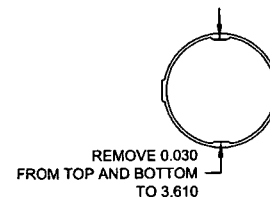
DETAIL K
SCALE 4X



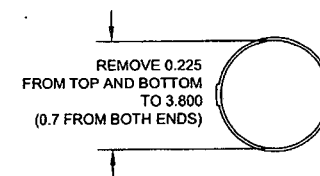
SECTION G-G
SCALE 5X



SECTION H-H
SCALE 5X



SECTION X-X
SCALE 5X



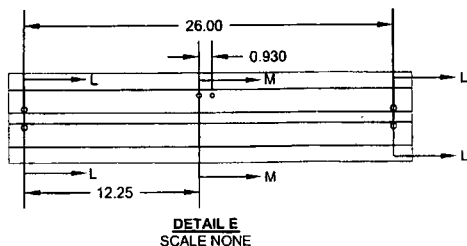
SECTION Y-Y
SCALE 5X

D3391-013 MID TUBE ASSEMBLY PARTS LIST

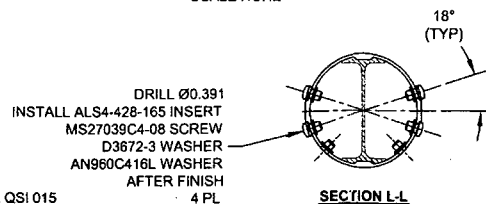
QTY	PART NUMBER	DESCRIPTION
X	D3391-013	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
4	D3672-1	WASHER
4	D3672-3	WASHER
12	D3681-1	SPACER
24	AELS-1032-130	INSERT
4	ALS4-428-165	INSERT
4	AN960C10L	WASHER
4	AN960C416L	WASHER
4	MS27039C1-09	SCREW
4	MS27039C4-08	SCREW

D3391-013 MID TUBE ASSEMBLY

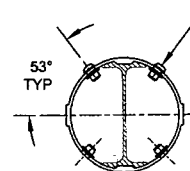
- 1) MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
- 2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/291 PER QSI 015
- 3) WELDING: PER DART QSI 004



DETAIL E
SCALE NONE



SECTION L-L
SCALE 5X

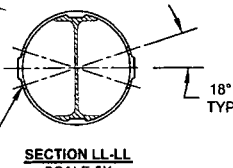


SECTION M-M
SCALE 5X

DRILL Ø0.297
INSTALL AELS-1032-130 INSERT
MS27039C1-09 SCREW
D3672-1 WASHER
AN960C10L WASHER
AFTER FINISH
4 PL

66005

DRILL Ø0.250
4 PL



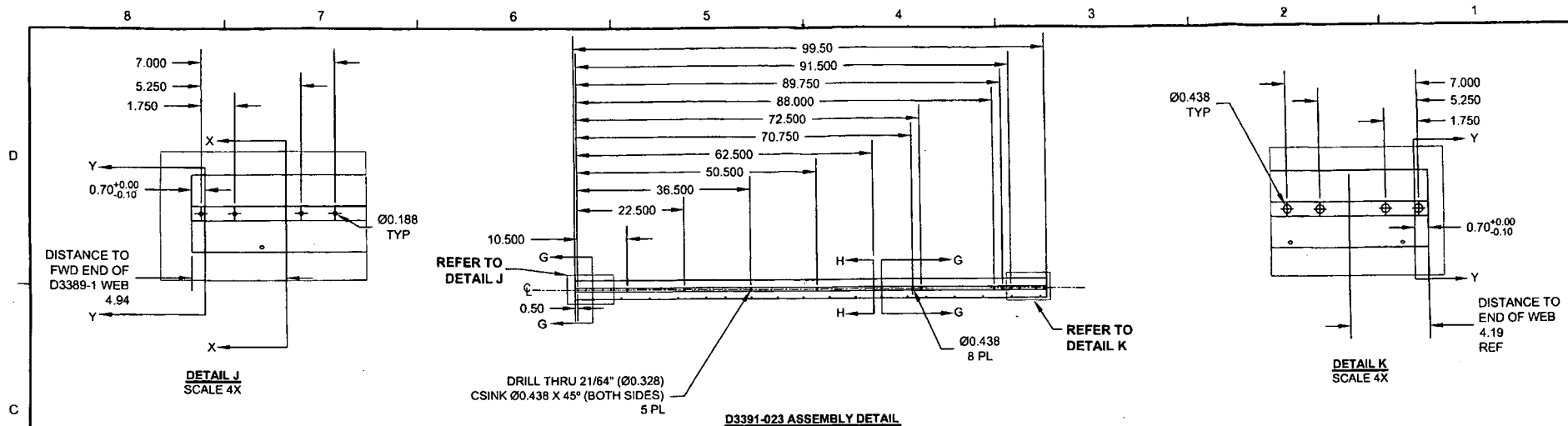
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SCALE 5X

DEO ATTACHED

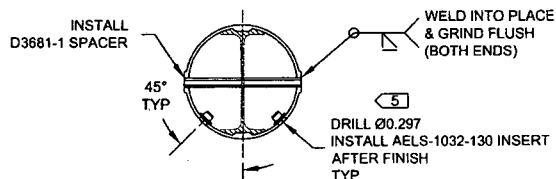
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DESIGN	PH	DART AEROSPACE USA, INC	
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CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D3391	SHEET 5 OF 8
APPROVED		TITLE	SCALE
DE APPR.		412 FLOAT SKIDTUBE	NTS
DATE	08.08.20	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC	

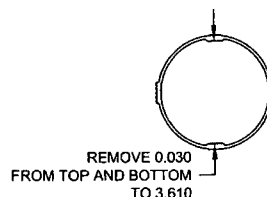
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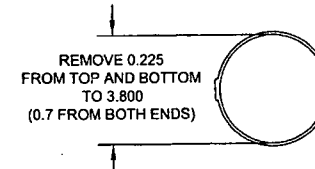
SECTION G-G
SCALE 5X



SECTION H-H
SCALE 5X



SECTION X-X
SCALE 5X







SECTION Y-Y
SCALE 5X

D3391-023 MID TUBE ASSEMBLY PARTS LIST

QTY - 023	PART NUMBER	DESCRIPTION
X	D3391-023	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
5	D3681-1	SPACER
20	AELS-1032-130	INSERT

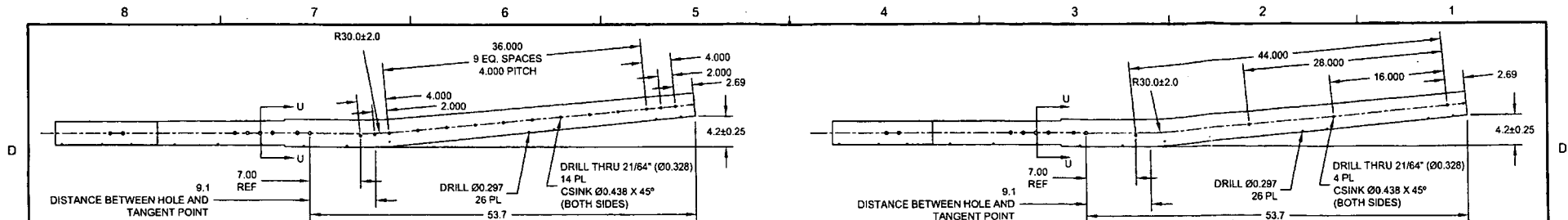
D3391-023 MID TUBE ASSEMBLY

- 1) MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
- 2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/-291 PER QSI 015
- 3) WELDING: PER DART QSI 004

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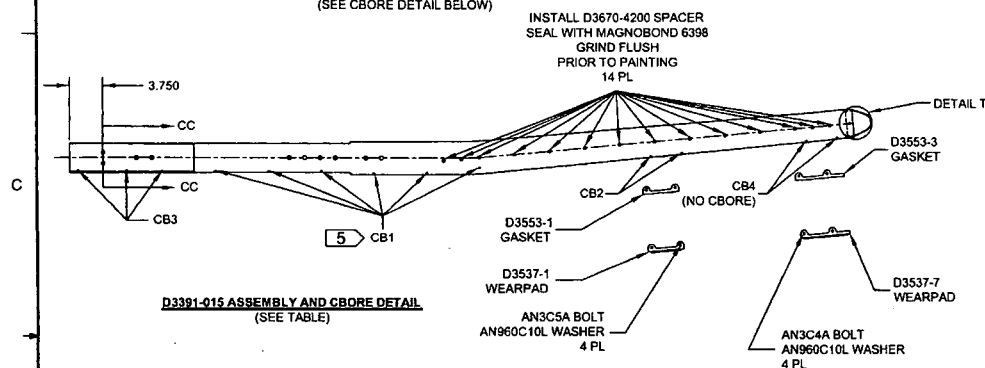
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RELEASED
08/27/05 JV

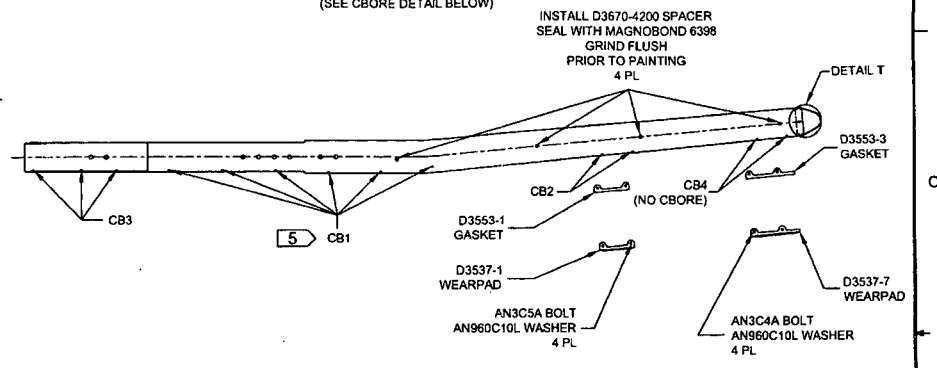


D3391-015 BENDING AND DRILLING DETAIL
(SEE CBORE DETAIL BELOW)

D3391-025 BENDING AND DRILLING DETAIL
(SEE CBORE DETAIL BELOW)



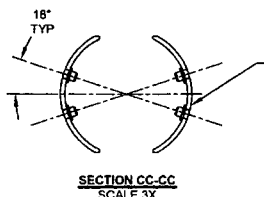
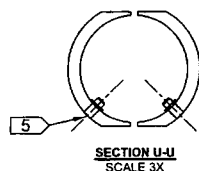
D3391-015 ASSEMBLY AND CBORE DETAIL
(SEE TABLE)



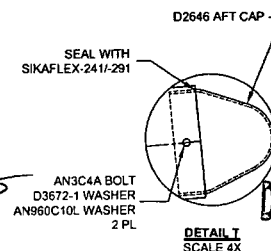
D3391-025 ASSEMBLY AND CBORE DETAIL
(SEE TABLE)

D3391-015/-025 AFT TUBE ASSEMBLY PARTS LIST

QTY - 015	QTY - 025	PART NUMBER	DESCRIPTION
X	X	D3391-015	AFT TUBE ASSEMBLY
		D3391-025	AFT TUBE ASSEMBLY
1	1	D6014-090	AFT TUBE
1	1	D2646	AFT CAP
1	1	D3537-1	WEARPAD
1	1	D3537-7	WEARPAD
1	1	D3553-1	GASKET
1	1	D3553-3	GASKET
14	4	D3670-4200	SPACER
2	2	D3672-1	WASHER
14	14	AELS-1032-130	INSERT
12	12	AELS-1032-225	INSERT
4		ALS4-428-165	INSERT
6	6	AN3C4A	BOLT
4	4	AN3C5A	BOLT
10	10	AN960C10L	WASHER



DRILL Ø0.391
CBORE Ø0.516 X 0.040 DEEP
INSTALL ALS4-428-165 INSERT
4 PL



CBORE HOLES MARKED CB1-CB4 AS FOLLOWS AND
INSTALL AELS-1032-XXX AFTER FINISH AS NOTED

HOLES MARKED	QTY D3391-015	QTY D3391-025	CBORE	P/N
CB1	12	12	Ø0.430 X 0.170	AELS-1032-225
CB2	4	4	Ø0.430 X 0.170	AELS-1032-130
CB3	6	6	Ø0.430 X 0.040	AELS-1032-130
CB4	4	4	NONE	AELS-1032-130

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08 09 05 MJD

DEO ATTACHED

DRAWING NO. D3391	TITLE 412 FLOAT SKIDTUBE	REV. H	DART AEROSPACE USA, INC ENGINEERING ORDER		D.E.O. NO. D3391-H-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>MP</i>	CHECKED <i>h</i>	MFG. APPR. <i>h</i>	APPROVED <i>MP</i>	DE APPR. <i>h</i>			
DATE 09.09.23	DATE 06.09.24	DATE 09/09/25	DATE 09/09/30	DATE 09/09/30			

PURPOSE:

LPS-3 IS NO LONGER USED DURING ASSEMBLY OF D3391-041/-043 SKIDTUBES.

CHANGE:

AMEND NOTE 2 OF D3391-041/-043 SKIDTUBE ASSEMBLIES (ZN A6-1, A6-2) AS FOLLOWS:

- 2) ~~SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH~~
~~AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH~~
 LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS
 OFF POWDER COATING WITH MEK DEGREASER.

RELEASED
 2010-02-02
MP

#66005